

Date: Friday, 30/05/2008 10:12:35 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BRACKET		
Job Number	39597			Part Number	D32941		
Estimate Number	11181			Drawing Number	D3294 REV A1		
P.O. Number	:			Project Number	N/A		
This Issue	30/05/2008 S.O. No. :			Drawing Revision	A1		
Prsht Rev.	NC			Material	:		
First Issue	/ / Type : SMALL /MED FAB			Due Date	10/06/2008 Qty: 20 Um: Each		
Previous Run	37035						
Written By	:						
Checked & Approved By	JUL 08.5.30						
Comment	Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3.080 sheet
		Comment: Qty.: 2.1072 sf(s)/Unit Total : 42.1449 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3294-1 Batch: 107460 HB 8-6-3
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3294 Dwg Rev: A1 HB 8-6-3 Prog Rev: A1
		2-Deburr if necessary HB 8-6-3
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 8-6-3
4.0	QC8	SECOND CHECK
		S 08/06/01-22
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		a/4 Done at step 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.06.10	2	SET GRAIN DIRECTION AT 45° REF DS EMAIL	B D.G.Y			IP 08.06.11 P.W. 08.04.12	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39597

Part Number: D32941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D32941

SB 08/06/10

(21)

7.0 QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP

S 08/06/10 (21)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fx 08/06/10

(21)

9.0 POWDER COATING

POWDER COATING



M102316

(21X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 11:50

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:20

M/

08/06/10

(21)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

Fx 08/06/10

(21)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 211

6/6/10

SP

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 08/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39597
Description: Bracket	Part Number:	D3294-1
Inspection Dwg: D3294 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>JB</u>	Audited by: <u>J</u>	Prototype Approval: N/A
Date: <u>8-6-3</u>	Date: <u>08/05/05</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	

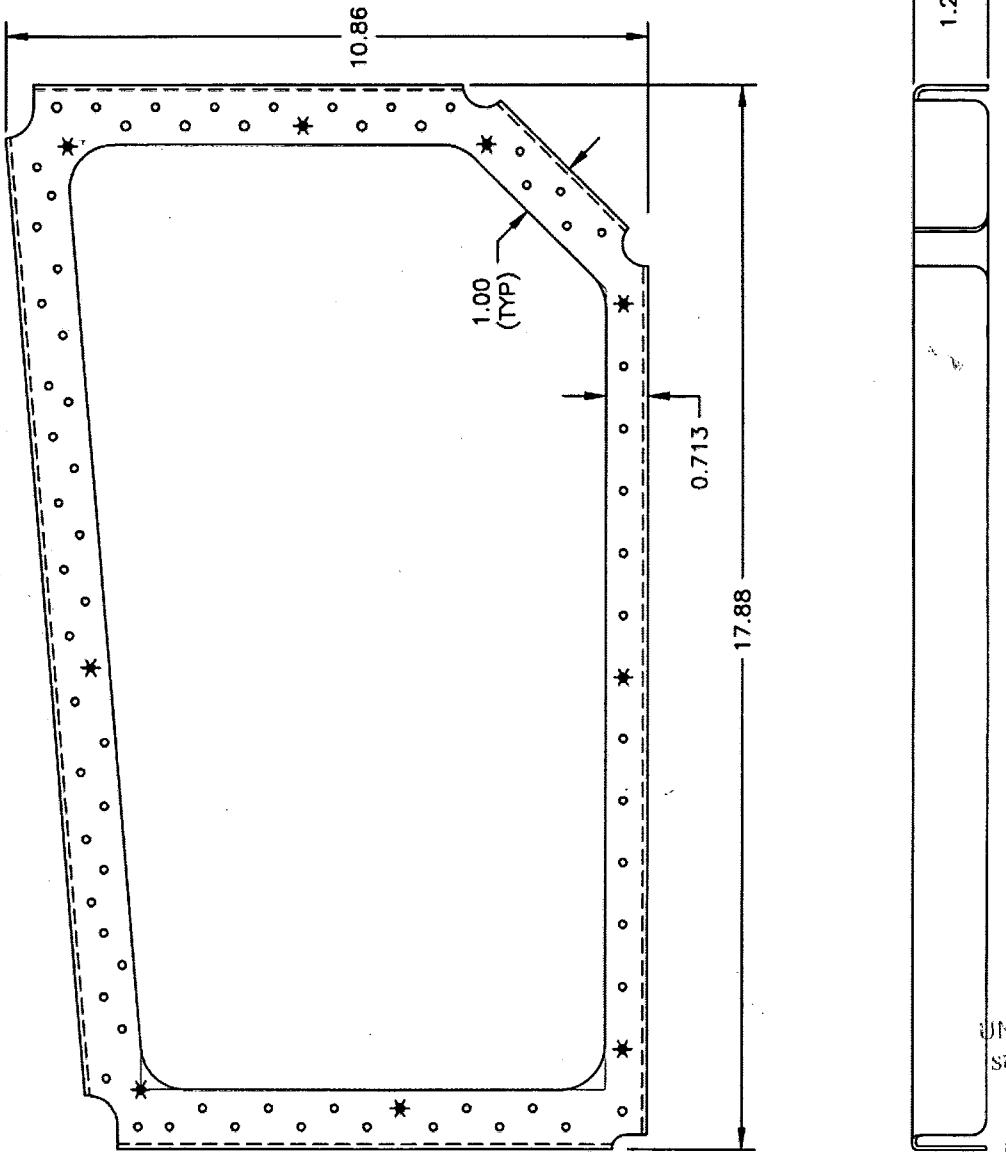


OF COPY IS
SHEET 1 OF 2

DESIGN	IP	DRAWN BY	91	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	IP	APPROVED	IP	DRAWING NO. D3294 REV. A SHEET 1 OF 2
DATE	04.06.28			TITLE SCALE
				BRACKET 1:3
A	04.06.28			NEW ISSUE
A1	IP	05.06.13		12.97 WAS 13.03, AS MANUFACTURED

RELEASED
04.07.12

D3294-1 BRACKET
1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
2) CHECK PER TEMPLATE D3294-1T1
3) MATERIAL: 2024-T3 (QO-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
6) USE MINIMUM BEND RADIUS OF 0.188"
7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 39597

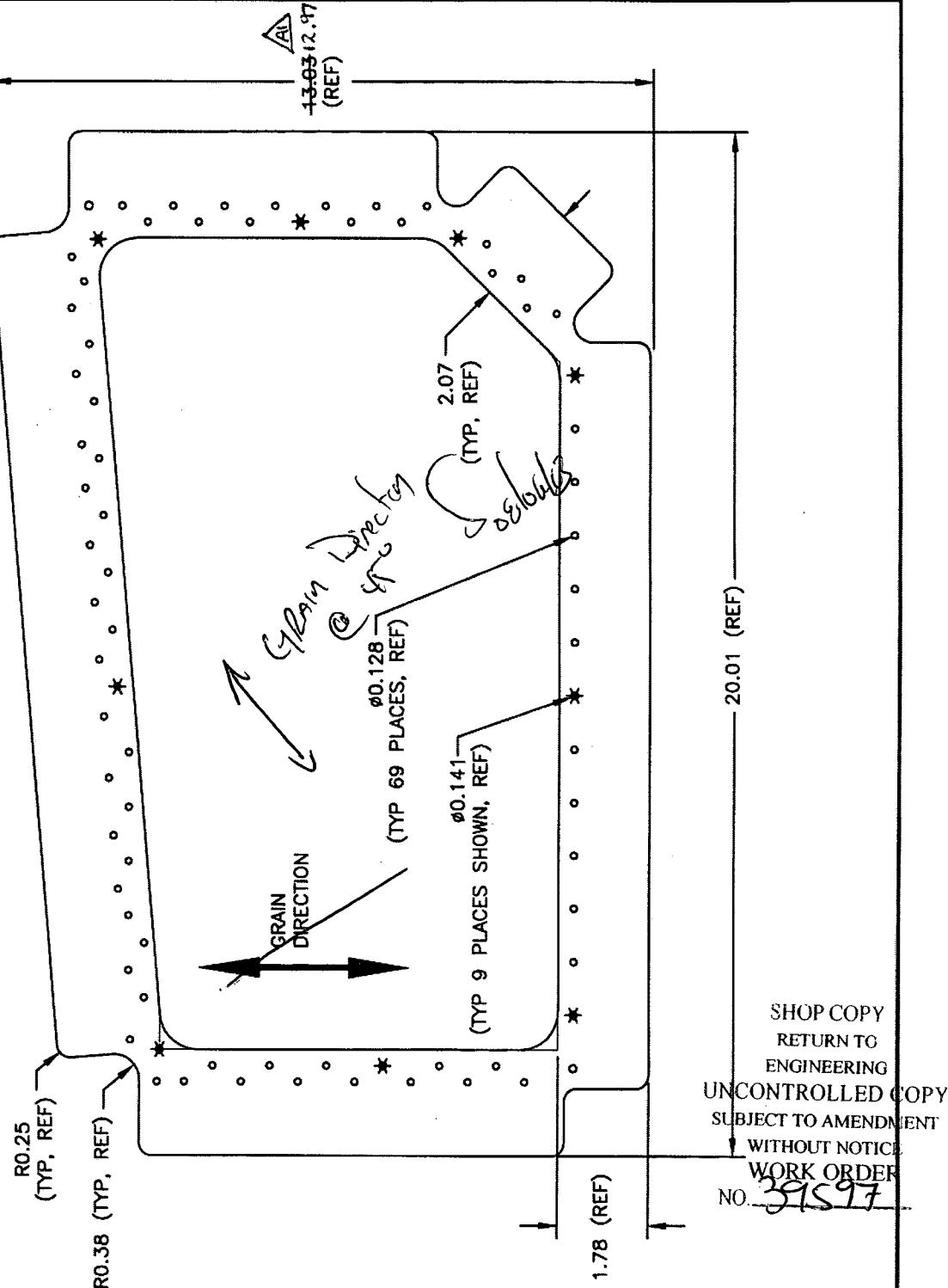
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3294
DATE	04.06.28	REV. A SHEET 2 OF 2 TITLE SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
04.07.12

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 11, 2008 3:28 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Peter Hum'
Subject: RE: NCR D3294-1

Chris,

Makes sense to me. Acceptable deviation.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, June 11, 2008 8:01 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; Peter Hum
Subject: NCR D3294-1

David,

We set the grain direction at 45 degrees for the D3294-1 Bracket (floor bracket for D350-567 vert ref window).
The bracket was cracking during bending when done per dwg. Is this acceptable?

Mike,

Dwg D3294 Rev. A should be updated to change the grain direction to 45 degrees.

-Chris

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 270.2.0/1494 - Release Date: 6/10/2008 7:22 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 270.2.0/1494 - Release Date: 6/10/2008 7:22 AM